

**THE FOLLOWING IS A REPOST OF ANOTHER DOCUMENT POSTED ON ARCHIVE.ORG CONTAINING BLUEPRINTS FOR A MARK II "STEN GUN". I HAVE BECOME ALARMED AT THE JOINT EFFORTS OF APPEASER GOVERNMENTS (SUCH AS THOSE IN SWEDEN) AND JIHADIST MIGRANTS TRYING TO SUBVERT CENTURIES-OLD ETHNO-NATIONAL AND CULTURAL ORDERS IN THE EUROPEAN WORLD. THUS, AM REPOSTING THIS FOR THE CONVENIENCE OF PARAMILITARY GROUPS WHOSE GOAL IS THE DEFENSE OF THE LOYAL CITIZENRY AND THE ANCIENT CULTURES THEY BELONG TO. BEING AS HOW THE STEN GUN IS ONE OF THE MOST ECONOMICAL OF ALL FULLY-AUTOMATIC FIREARMS, AND CAN BE EASILY MADE IN SMALL MACHINE SHOPS, IT IS THE BEST CANDIDATE FOR CITIZENS MILITIAS AND NATIONALIST PARAMILITARY GROUPS, SHOULD THE NEED TO DEFEND THEMSELVES AGAINST MALICIOUS COALITIONS OF APPEASER GOVERNMENTS AND JIHADIST GROUPS.**

**LEGALLY SPEAKING, I DO NOT OFFICIALLY ENDORSE THE CONSTRUCTION OF OR USE OF THIS WEAPON OR OTHERS LIKE IT. HOWEVER, THE READER MUST EXAMINE PAST EVENTS TO BECOME AS AWARE AS POSSIBLE THAT THE ACTIONS WHICH WERE THE MOST JUST WERE ALSO OFFICIALLY ILLEGAL.**

**IN SOME OF THESE CASES, REFUSAL TO TAKE LIBERTIES WITH LAWS HAVE GOTTEN THOUSANDS OF PEOPLE KILLED.**

**DON'T BE ONE OF THOSE STATISTICS.**

**SUMMANI**

# The STEN MKII

## Complete machine plans



STEN SUBMACHINE GUN, 9-millimetre submachine gun that became the standard such weapon in the British Commonwealth armed forces during World War II. Moreover, hundreds of thousands of Sten guns were provided to underground movements everywhere in Europe during that war. The gun was so ubiquitous that its name became all but a generic term for submachine gun. The Sten gun remained in service until the late 1950s.

The most common version of the Sten gun was 30 inches (76.2 cm) long with a barrel of 7.5 inches (19 cm). It fired at a rate of 550 rounds per minute, and it had a 32-round box magazine that, however, tended to jam if more than 30 rounds were loaded. The butt was a steel frame that, with the barrel, could be removed without difficulty so that the disassembled weapon could be easily hidden. Its weight was just over six pounds (2.7 kg) unloaded.

**Please set up Acrobat to “View - Bookmarks and Page”**



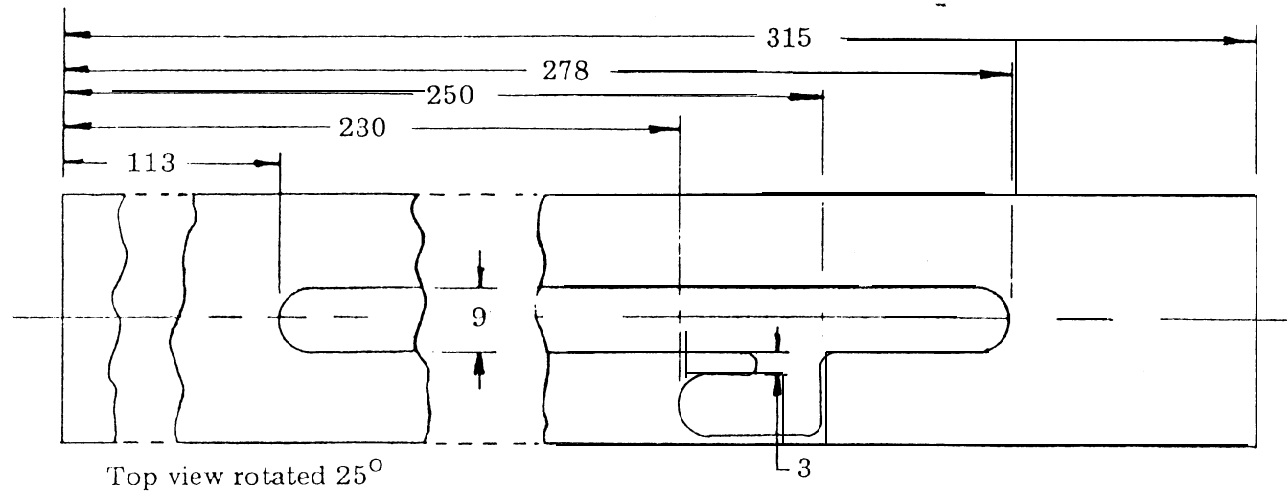
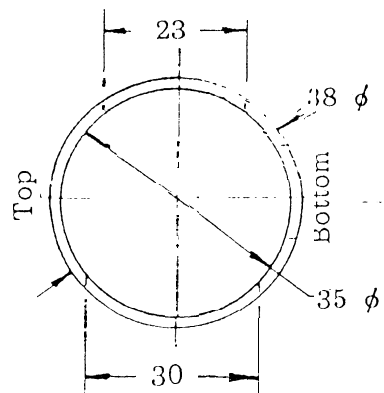
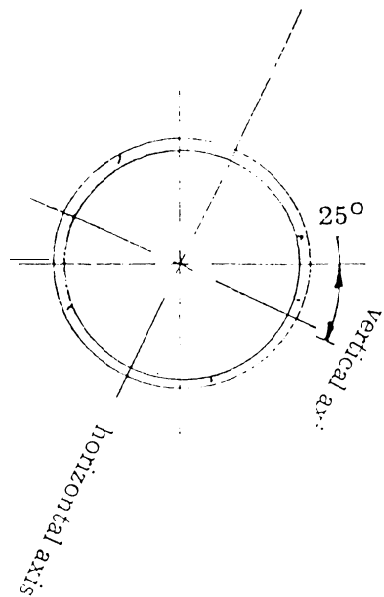
## Sten Mk II

### PARTS LIST

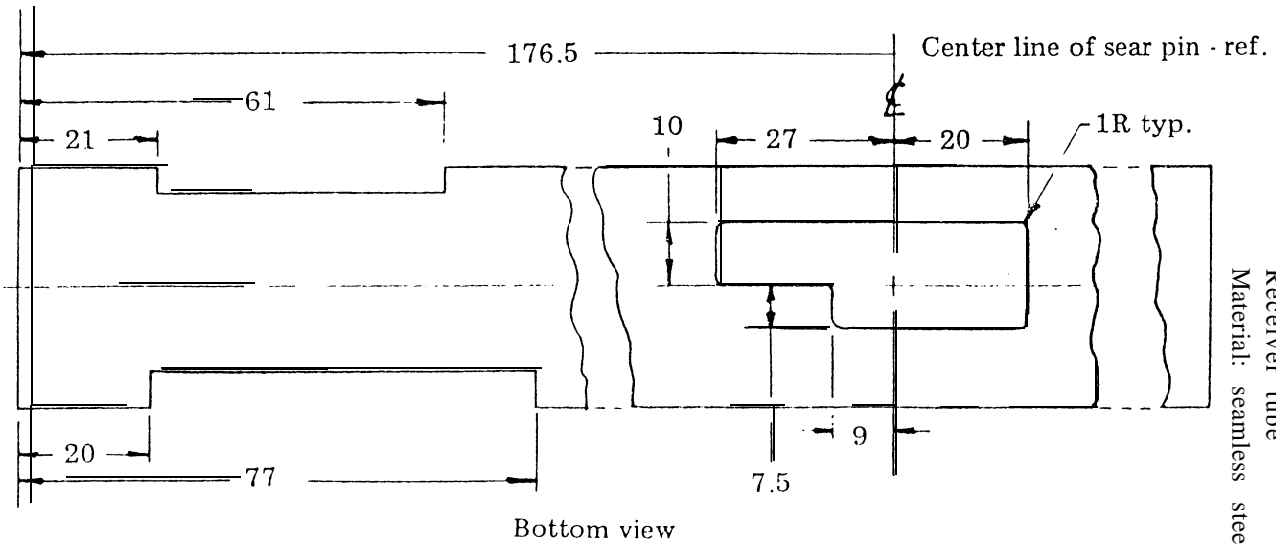
- |                                       |                                     |
|---------------------------------------|-------------------------------------|
| 1. Barrel                             | 24. Sear                            |
| 2. Barrel sleeve                      | 25. Sear spring                     |
| 3. Barrel sleeve lock                 | 26. Sear pin                        |
| 4. Barrel sleeve lock spring          | 27. Bolt                            |
| 5. Front sight                        | 28. Firing pin                      |
| 6. Barrel bushing                     | 29. Extractor                       |
| 7. Receiver tube                      | 30. Extractor spring                |
| 8. Receiver cap                       | 31. Extractor pin                   |
| 9. Trigger housing                    | 32. Bolt handle                     |
| 10. Butt stock assembly: stock tubing | 33. Closing spring                  |
| butt plate                            | 34. Closing spring cup              |
| stock grip                            | 35. Trigger housing cover           |
| stock ring                            | 36. Trigger housing cover screw (2) |
| 11. Magazine housing                  | 37. Magazine housing                |
| 12. Magazine housing spacer           | 38. Magazine follower               |
| 13. Magazine housing spacer screw     | 39. Magazine spring                 |
| 14. Magazine latch                    | 40. Magazine spring latch           |
| 15. Magazine latch spring             | 41. Magazine bottom                 |
| 16. Trigger                           | 42. Rear sight                      |
| 17. Trigger spring                    |                                     |
| 18. Trigger pin                       |                                     |
| 19. Disconnecter                      |                                     |
| 20. Disconnecter pin                  |                                     |
| 21. Selector                          |                                     |
| 22. Selector spring                   |                                     |
| 23. Selector plunger (2)              |                                     |

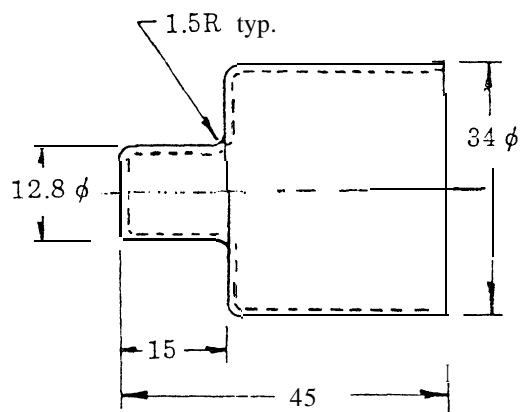
### NOTES:

1. Bolt stopping surface on barrel is 1mm forward of magazine well slot.
2. Bolt stroke is



Scale: .87 : 1

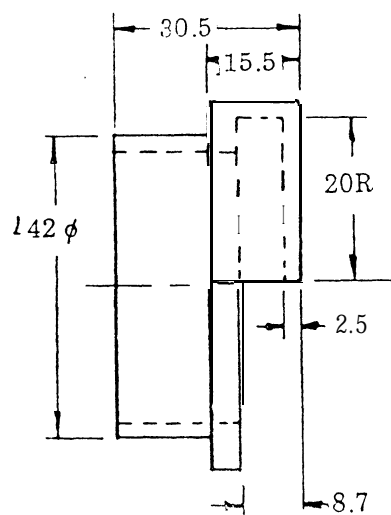




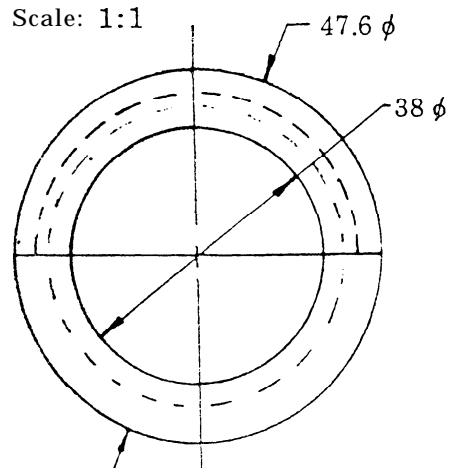
Main spring cap  
Material: 1mm stock

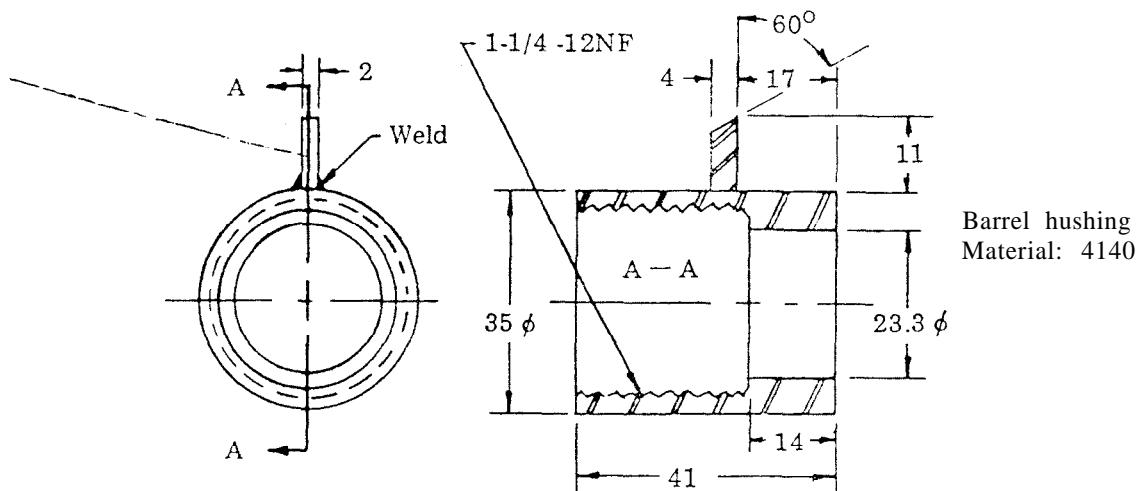
Scale: 1:1

Receiver rear end bushing  
Material: AISI 1010 or equivalent

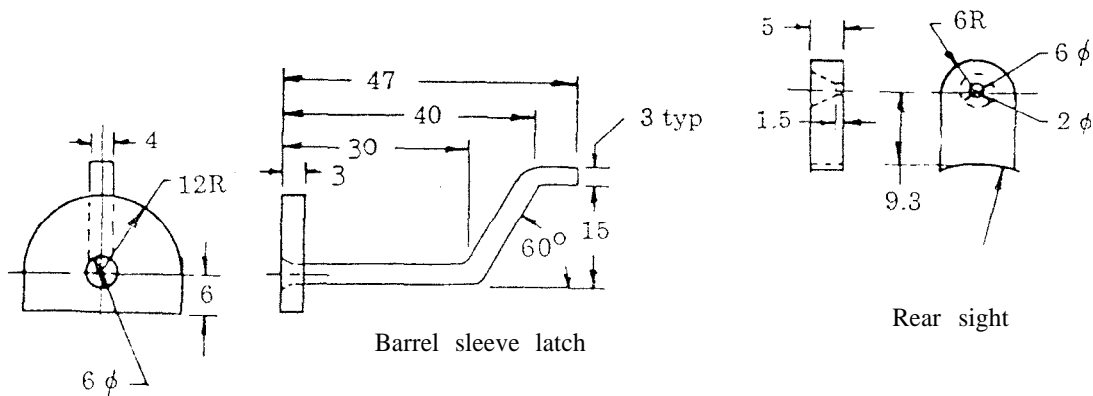
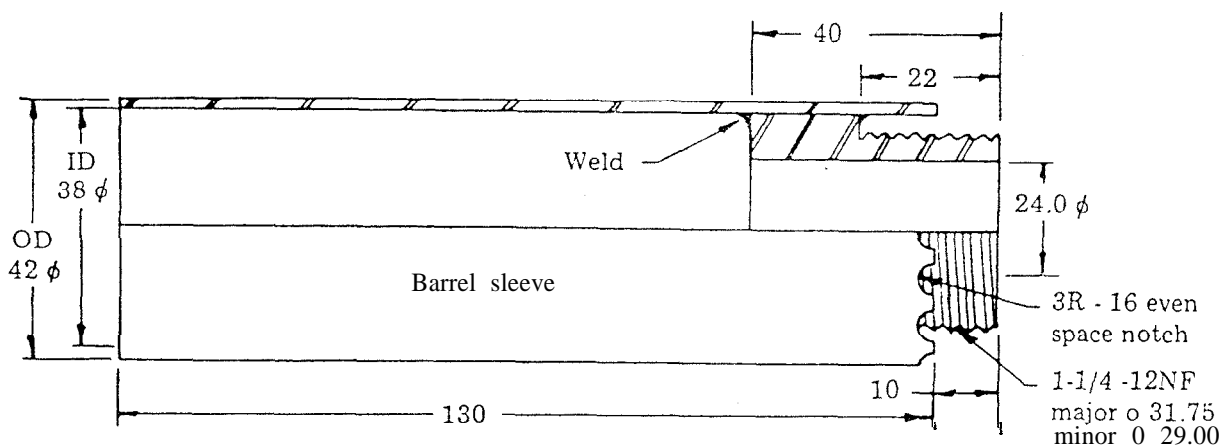


Scale: 1:1



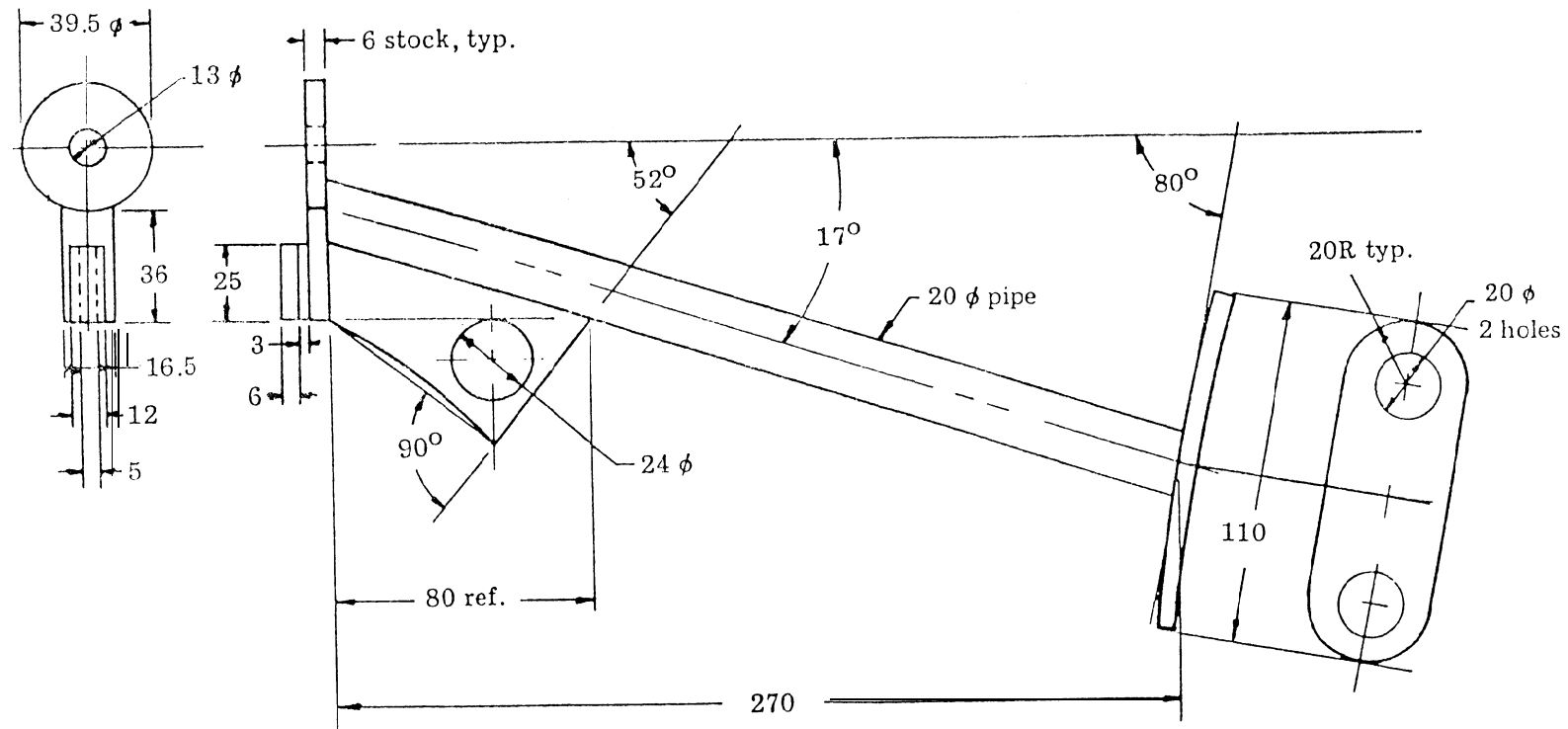


Scale:



Note: Stake at assembly  
with magazine housing

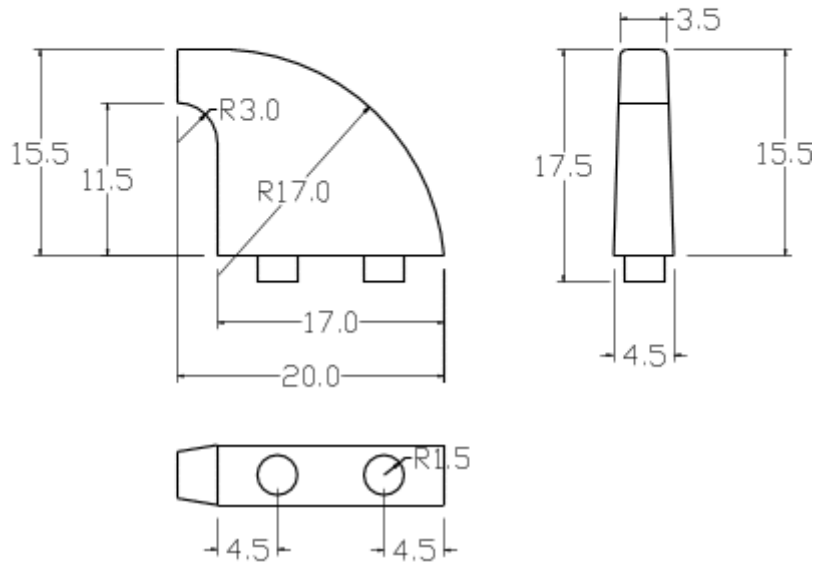
Butt-stock assembly  
Material: low carbon steel  
or aluminum, welded construction



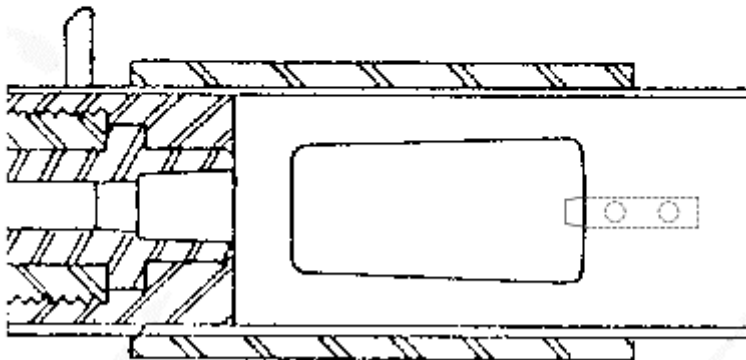
# Ejector

Material: 4140 steel, hardened.

Construction: Mill, or filed from stock, pins shown can be replaced by slotting the receiver and welding in place, although harder to position

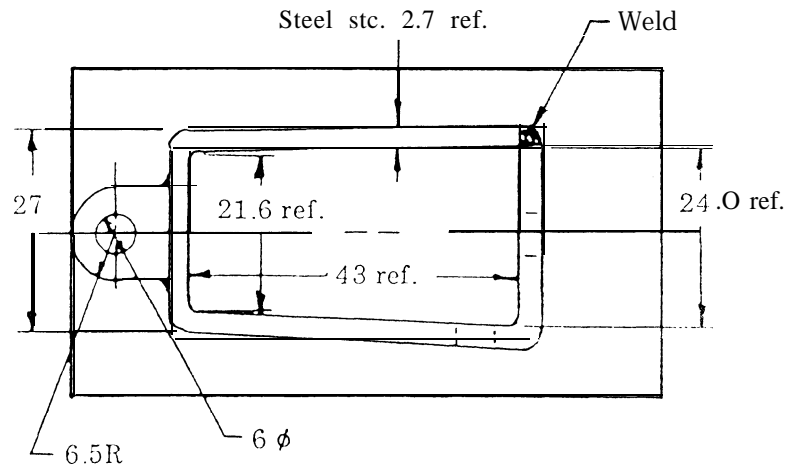
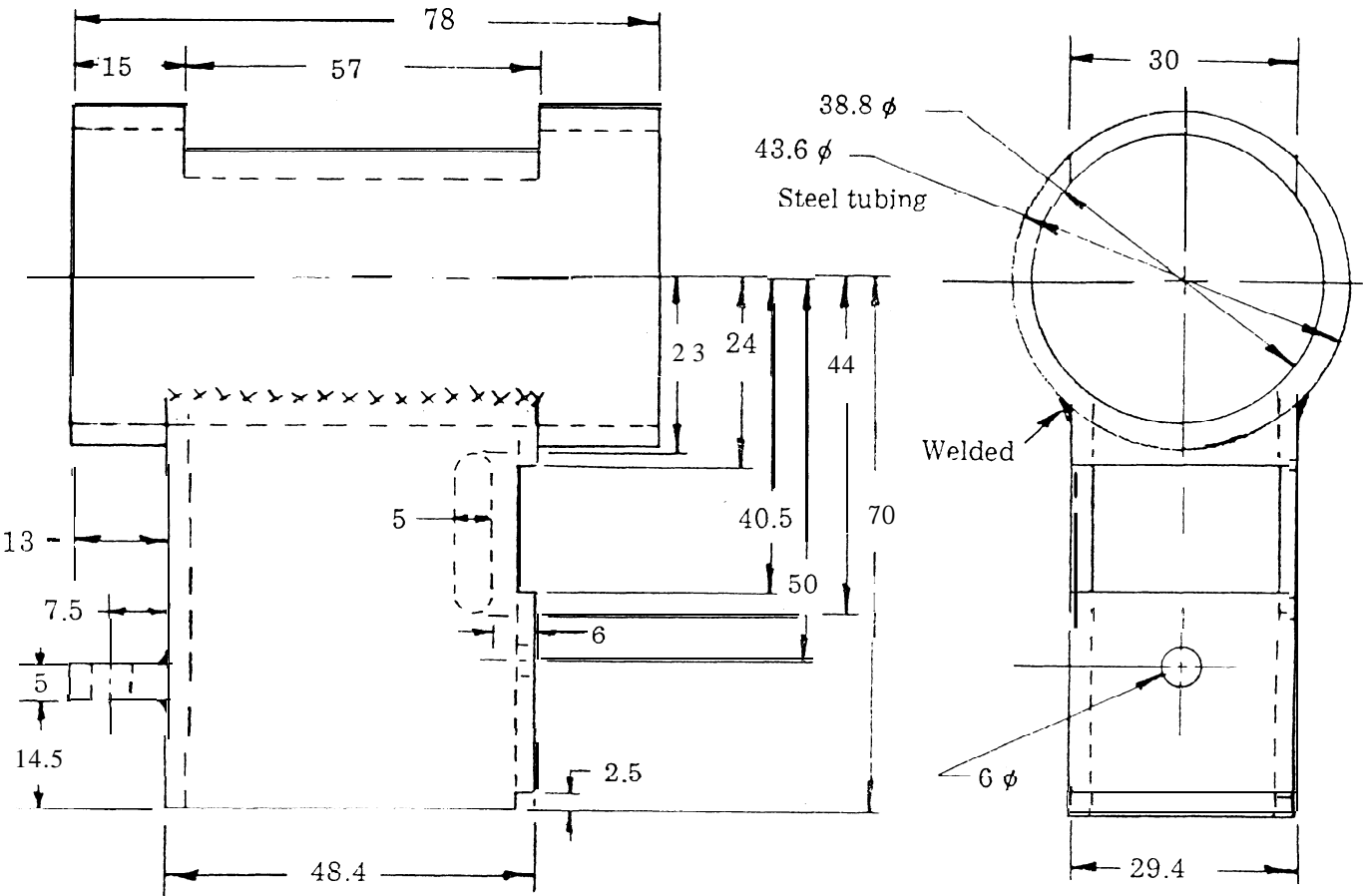


The ejector is positioned central with the magazine aperture of the receiver tube as shown. Construction can vary, here an ejector supported by two pins through the receiver tube is welded in place.



Magazine housing  
Material: as noted

Scale: 1 : 1

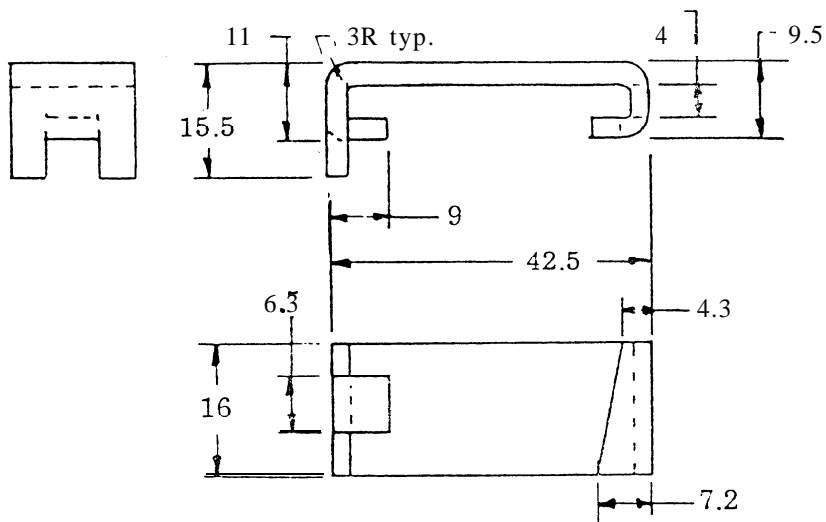


Magazine latch

Material: AISI 1010 or equivalent

2.7mm stock. Case harden 0.1mm deep

Scale: 1:1

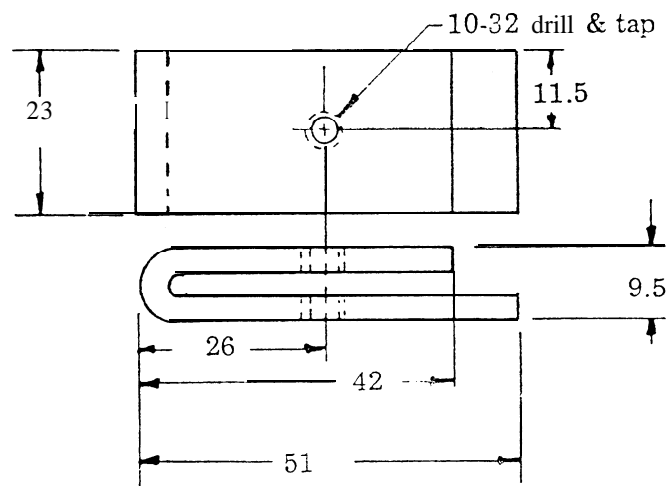


Magazine housing spacer

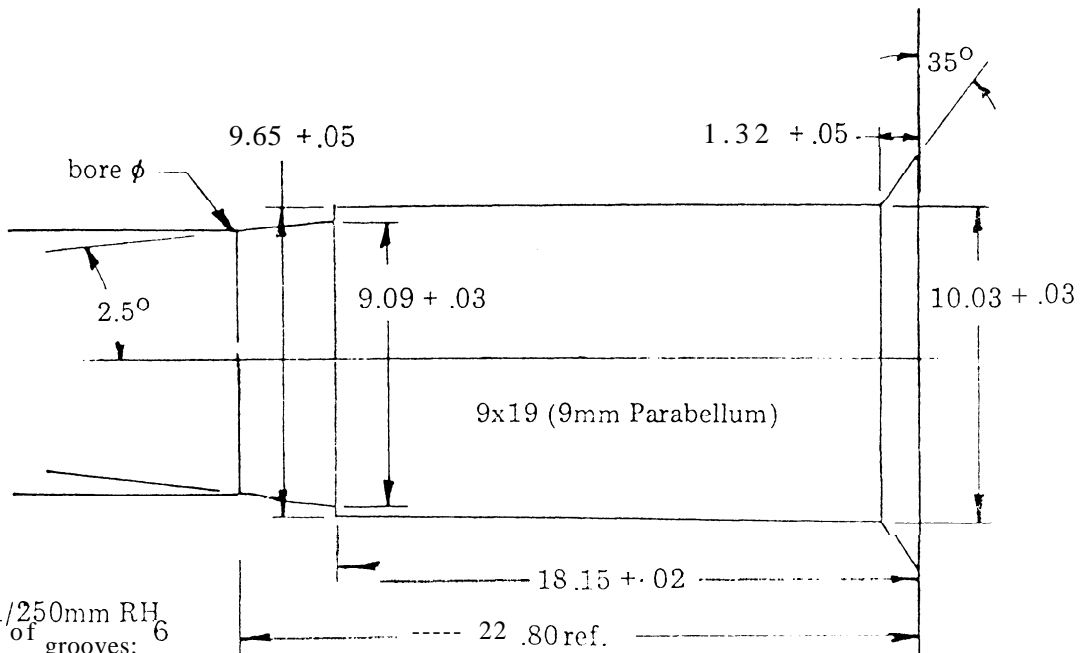
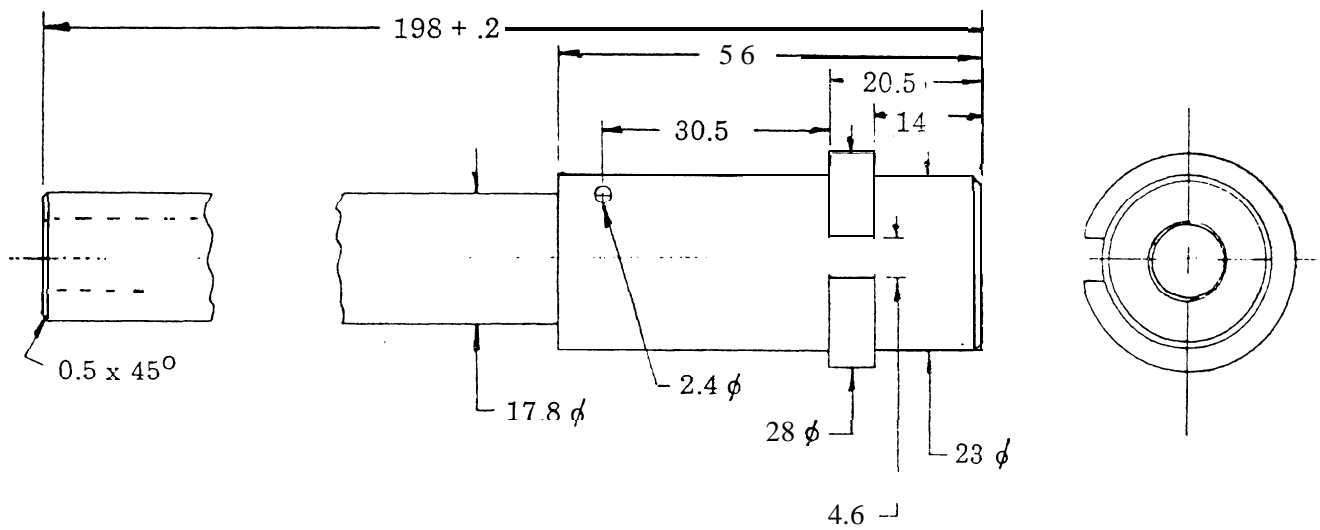
Material: AISI 1010 or equivalent

3mm stock. Heat treat: none

Scale: 1:1



Barrel  
Material: AISI 4140  
Harden to: Br 255-277



Twist: 1/250mm RH  
Number of grooves: 6  
Groove width:  $2.5 + .02$   
Bore diameter:  $8.84 + .02$   
Rifling diameter:  $9.06 + .05$

## STEN Mk II SPECIFICATIONS

1. Cartridge:	9mm Parabellum	
	Bullet weight	116 grains
	Powder weight	6 grains
	Muzzle velocity	1400 ft./sec.
2. Recoil Spring:	Wire diameter	0.067 in.
	Spring OD	1.00 in.
	Active coils	15
	Free length	9.40 in.
	Initial length	6.80 in.
	Final length	3.20 in.
	Work stroke	3.60 in.
3. Bolt:	Weight	1.327 lb. (9290 grains)
	(including extractor)	
	Cocking handle	0.077 lb. (540 grains)
Total recoiling weight:		1.404 lb. (9830 grains)
	Bolt maximum dia.	1.381 in.
	Bolt overall dia.	5.75 in.
	Bolt body length	4.21 in.

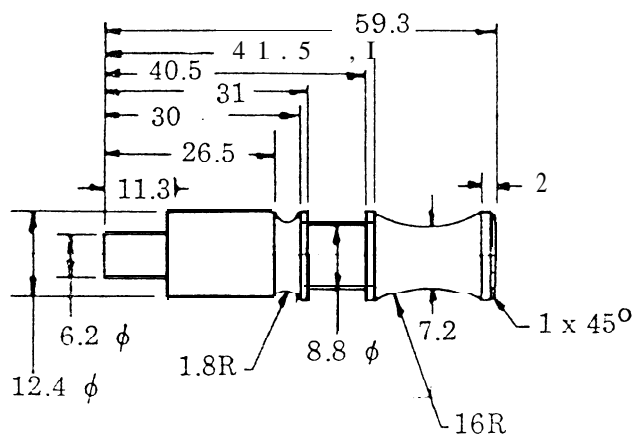
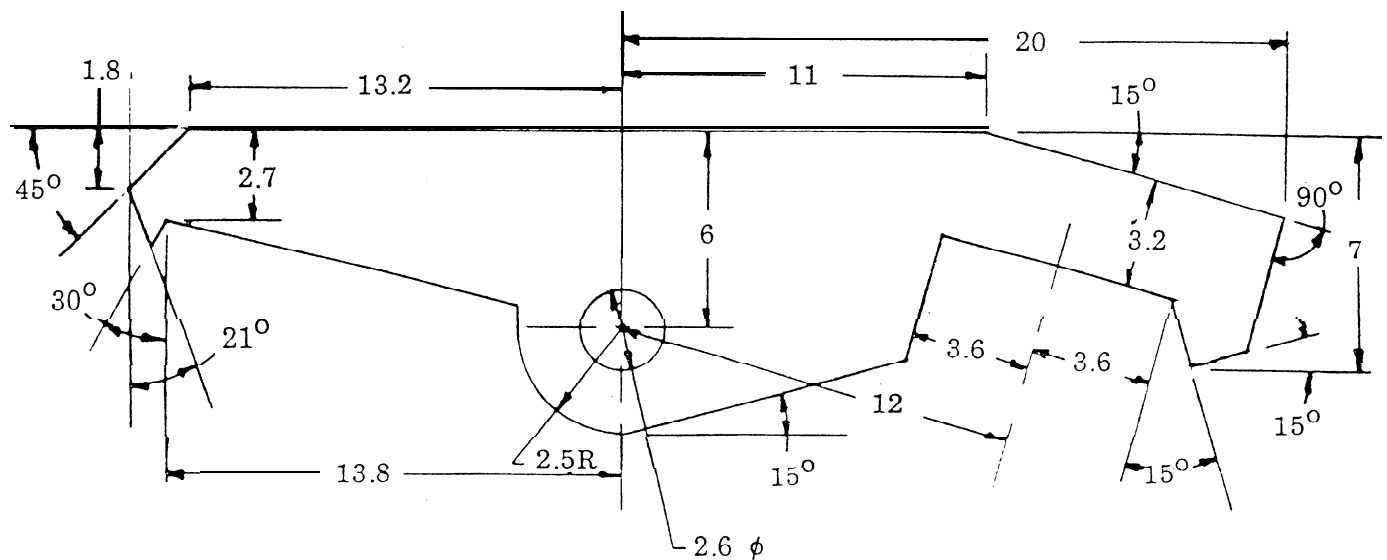
## SUGGESTED STEN MANUFACTURING MODIFICATIONS

- Select suitable lightwall steel tubing which is commercially available. For example, a fence post pipe (galvanized) is 38.5mm OD and 35.0mm ID, most suitable for use as a receiver.
- Eliminate barrel sleeve.
- Weld barrel bushing into the front end of the receiver for simple, permanent assembly.
- Turn barrel blank OD (outside diameter) without any shoulder, fit the barrel in the bushing by sliding fit.
- Fasten the barrel in the bushing by two roll pins of 3/16" diameter, or equivalent.
- Turn the bolt OD to fit the receiver ID.
- The external portion of the cocking handle (sticking out of the receiver) may be a straight 8.8mm OD, the same as the inside.
- The trigger housing cover acts only as a guard against dirt entering the trigger assembly. This cover can be eliminated or made from plastic.
- All pins can be roll pins of standard commercial size, or pieces of drill rod.
- All springs can be of a standard commercial size.
- Trigger material may be aluminum or plastic, side tabs may be replaced by spacers or washers to keep the trigger located neutrally.
- 1-1/4" diameter nominal size galvanized pipe, schedule 40 is suitable for a modified receiver:  
OD: 42.2mm  
ID: 35.05mm  
Wall thickness: 3.55mm

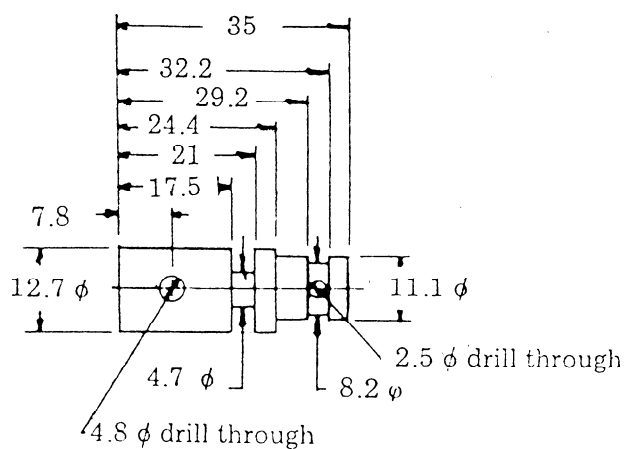
Note: A 1" galvanized pipe fits loosely inside a 1-1/4" pipe and can be welded as a filler-spacer where needed,

Extractor  
Scale: 4.5 : 1

Material: AISI 1040 or equiv., stock 4.7 wide  
harden to: Rc 48-52



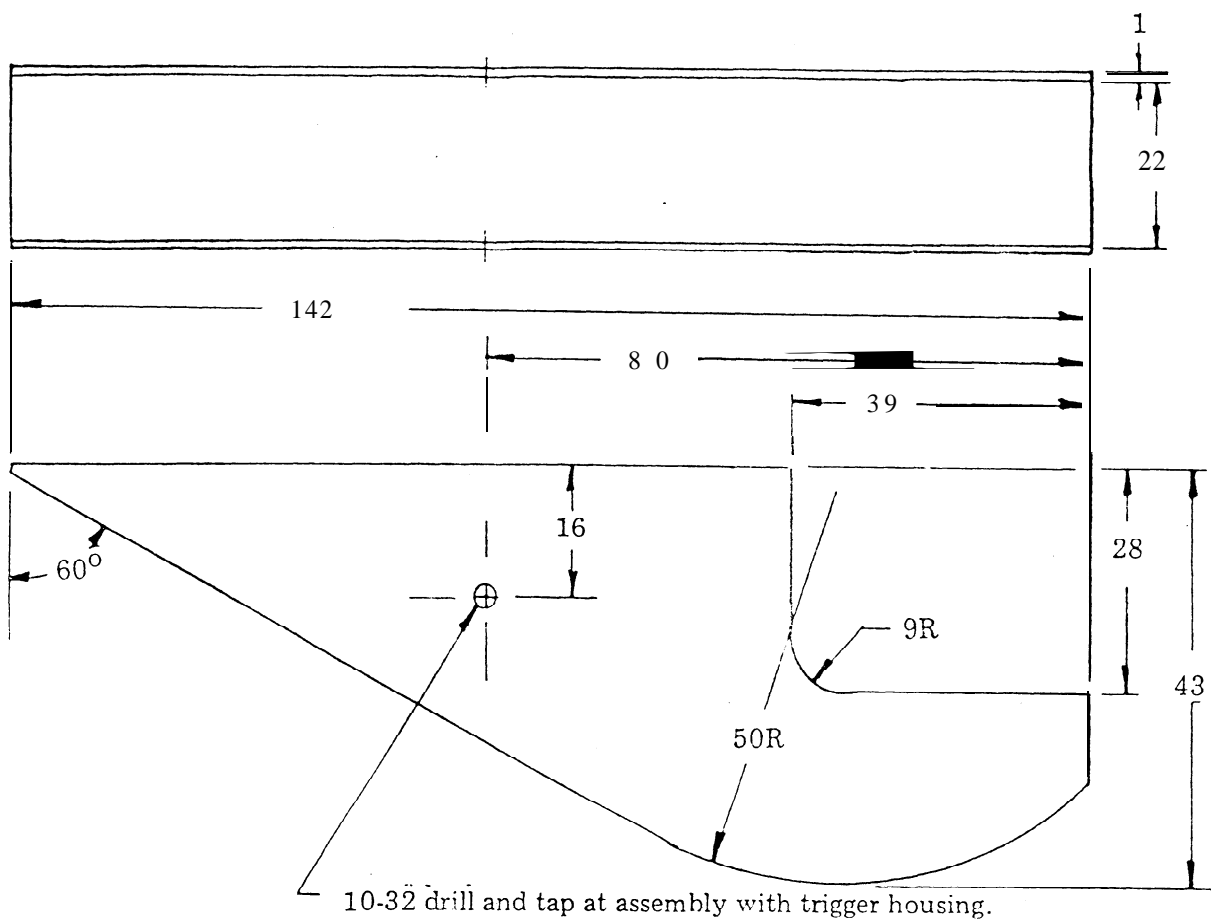
Bolt handle  
Scale: .87:1  
Material : mild steel  
Heat treat: none



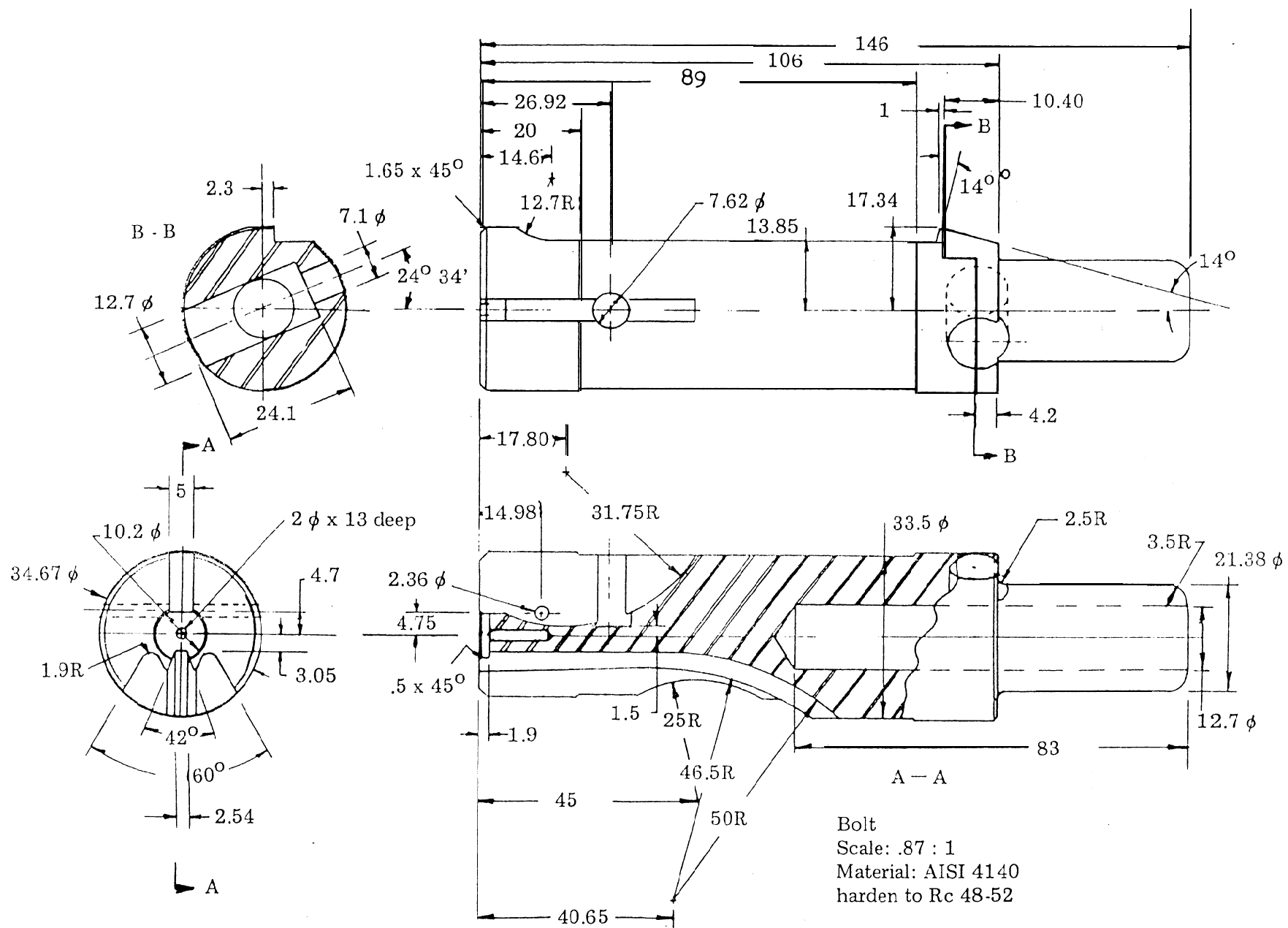
Selector  
Scale: .87:1  
Material: mild steel  
Heat treat : none

Trigger housing cover  
Material: 1mm stock, formed  
Required: 1

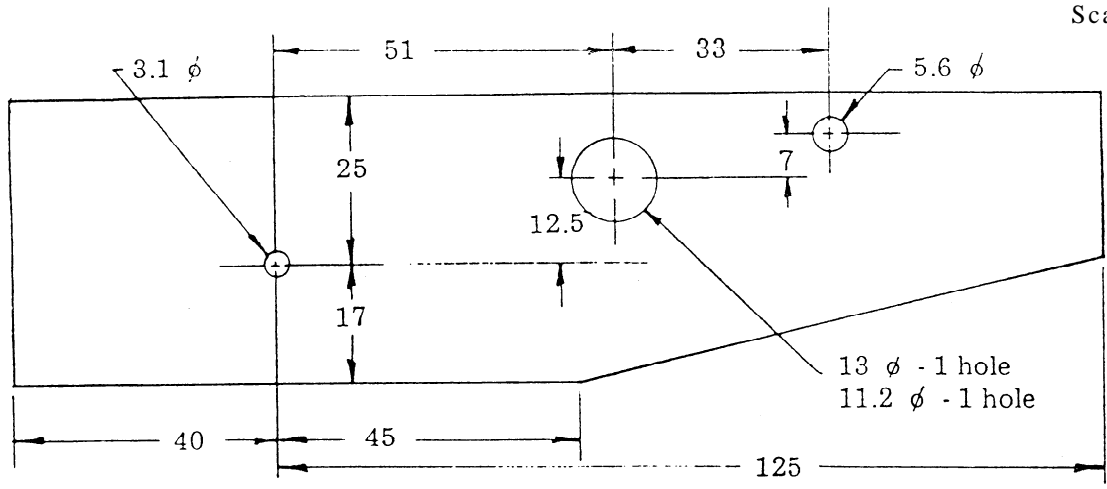
Scale: 1:1



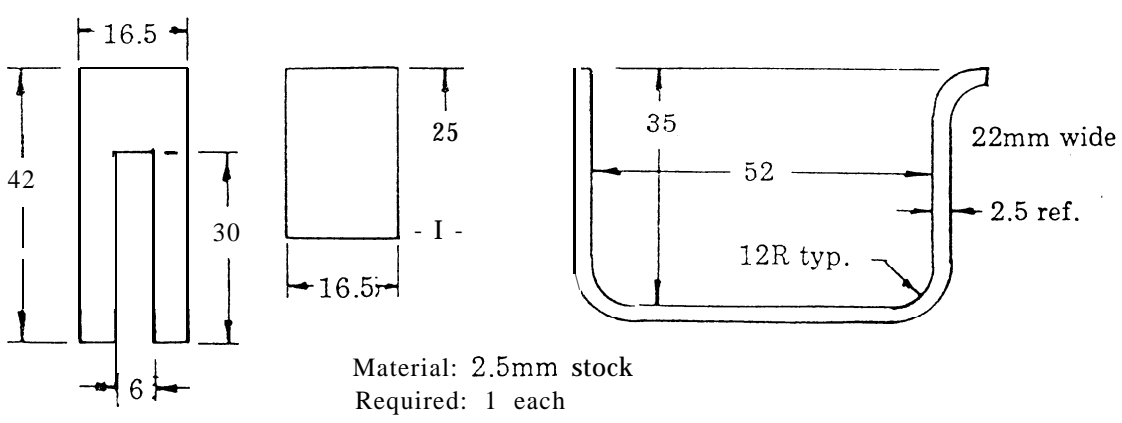
All Sten screws are 10-32 thread, round head type. Trigger housing screws (2) are 13mm long.



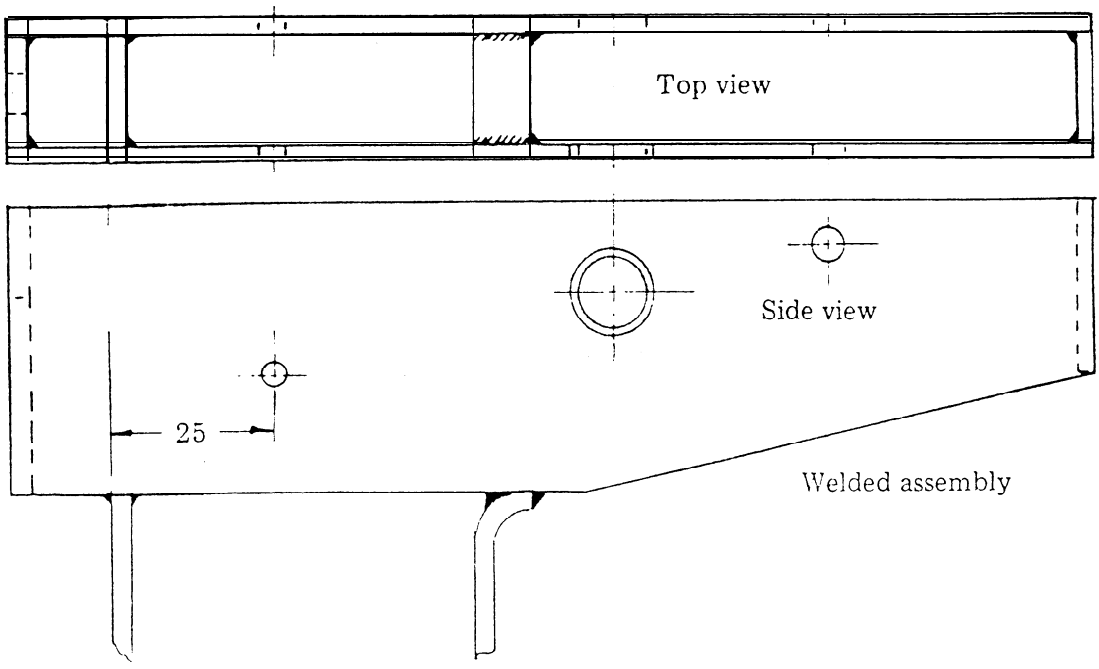
Trigger housing  
Scale: .87:1

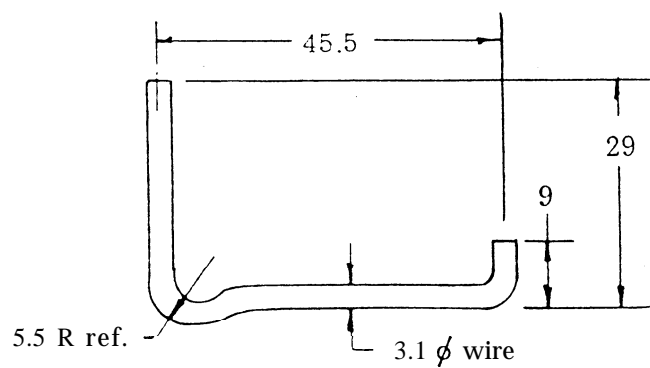


Material: 2.5mm stock  
Required: 2



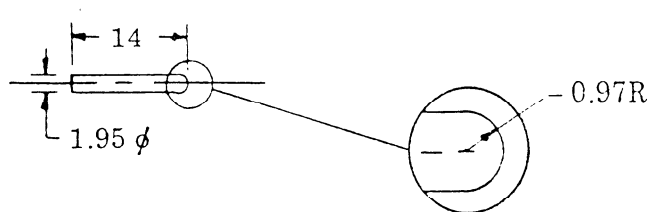
Material: 2.5mm stock  
Required: 1 each





Trigger pin

Note: Trigger pin may be substituted by spring pin 3.1 φ by 26 long.



Firing pin  
Material: Drill rod  
Harden to Rc 50

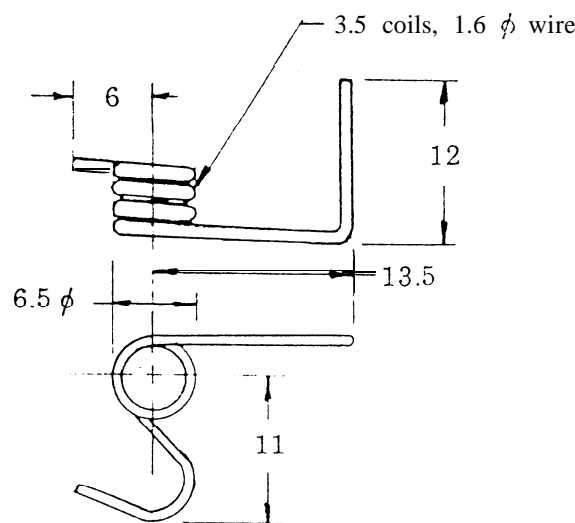
#### PINS (Spring pins)

USE	DIAMETER	LENGTH
Extractor	2.5	25
Sear	5.5	24

SPRINGS

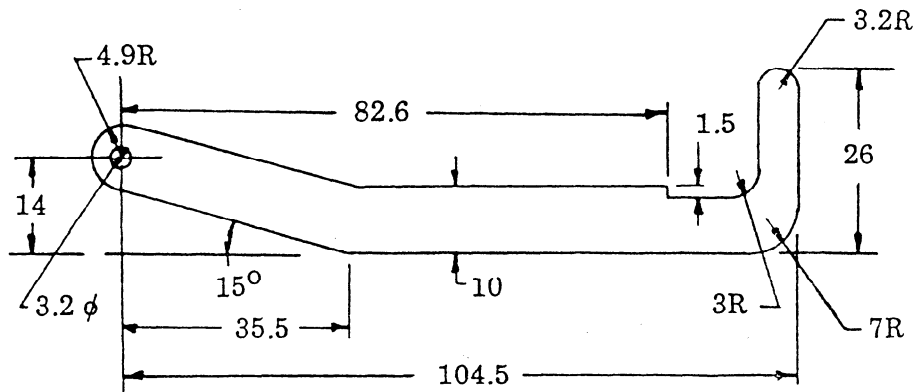
USE	Wire dia.	Coil OD	Free length	Number of coils	Coil ends	SUBSTITUTE”:
Extractor	1	7.1	12	5.5	Sq.	LC-040C-4
Magazine latch	1	8.7	15.5	6	Gr.	LC-040C-6
Closing	1.6	26.5	245	17	Sq.	
Trigger	0.7	4.6	57	72	Extension spring loops	LE-026B-7 or LE-026C-8
Selector	0.45	4.6	14	8	Gr.	LC-018B-6
Barrel sleeve latch	1	8.7	35	15	Sq.	

Sear spring, formed  
substitute LT-059K-1-R



\*Lee Spring Company, 30 Main St., Brooklyn, NY 11201; catalog No. 112/1970

Scale: .87 : 1



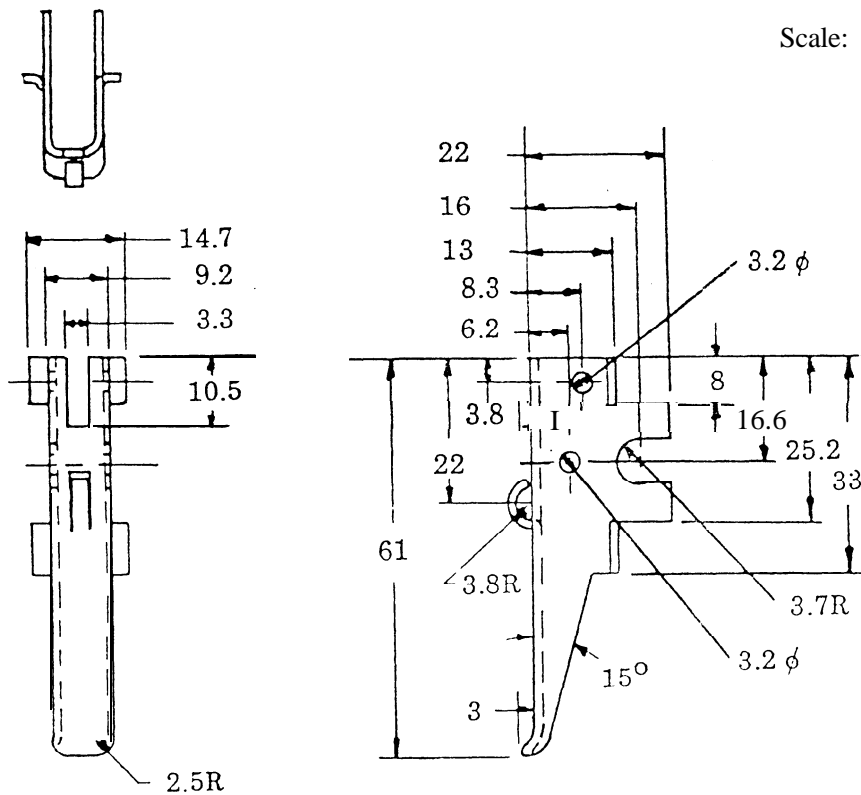
#### Trigger

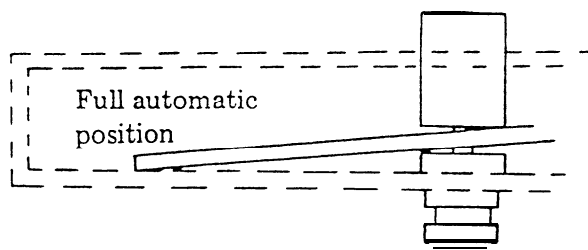
Material: AISI 1010 or equivalent,,

1.6mm stock

Heat treat: none

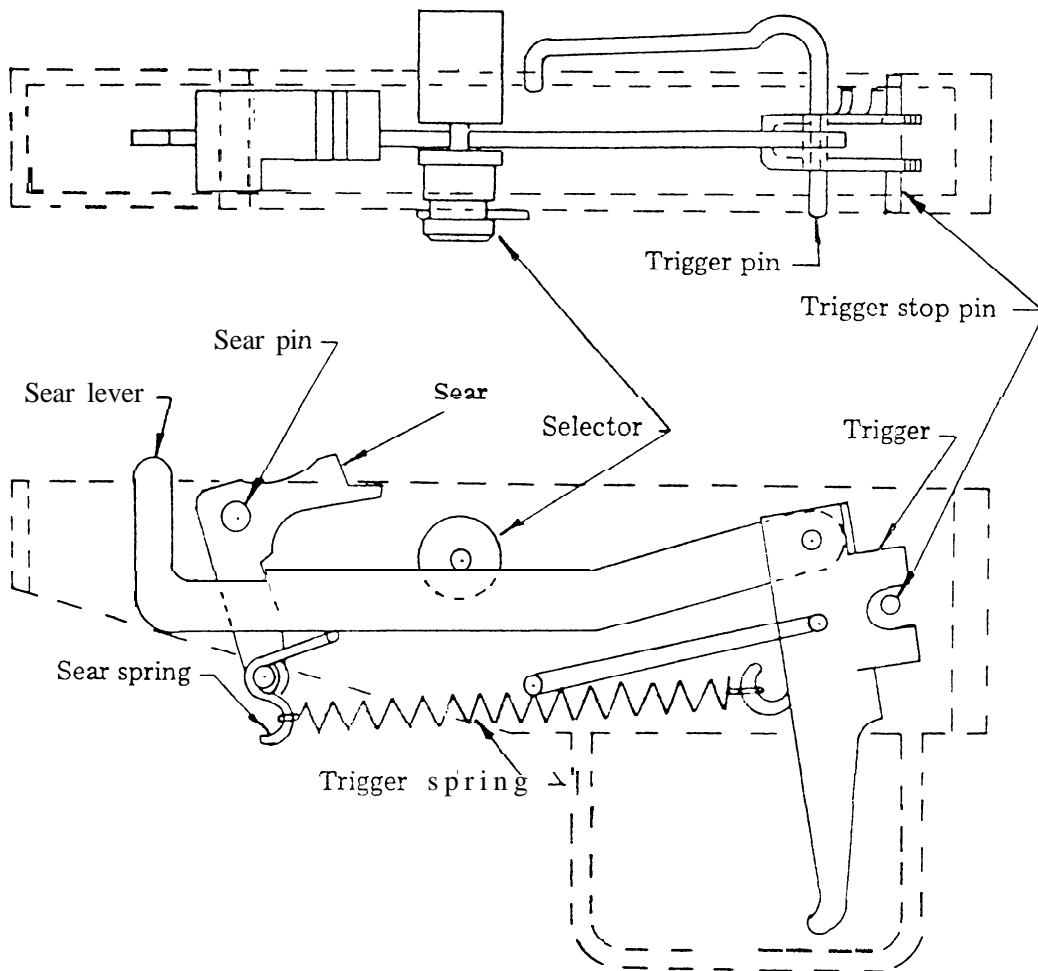
Scale: .87 : 1



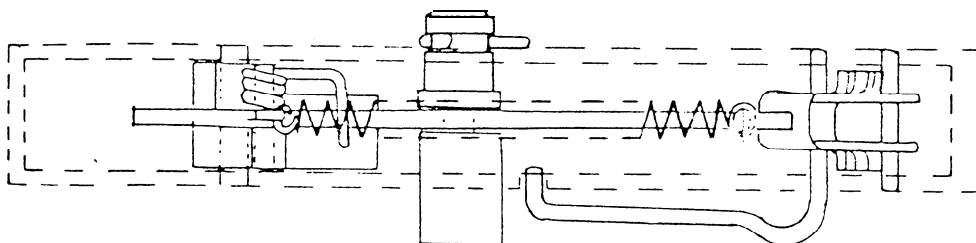


Top view

Trigger assembly

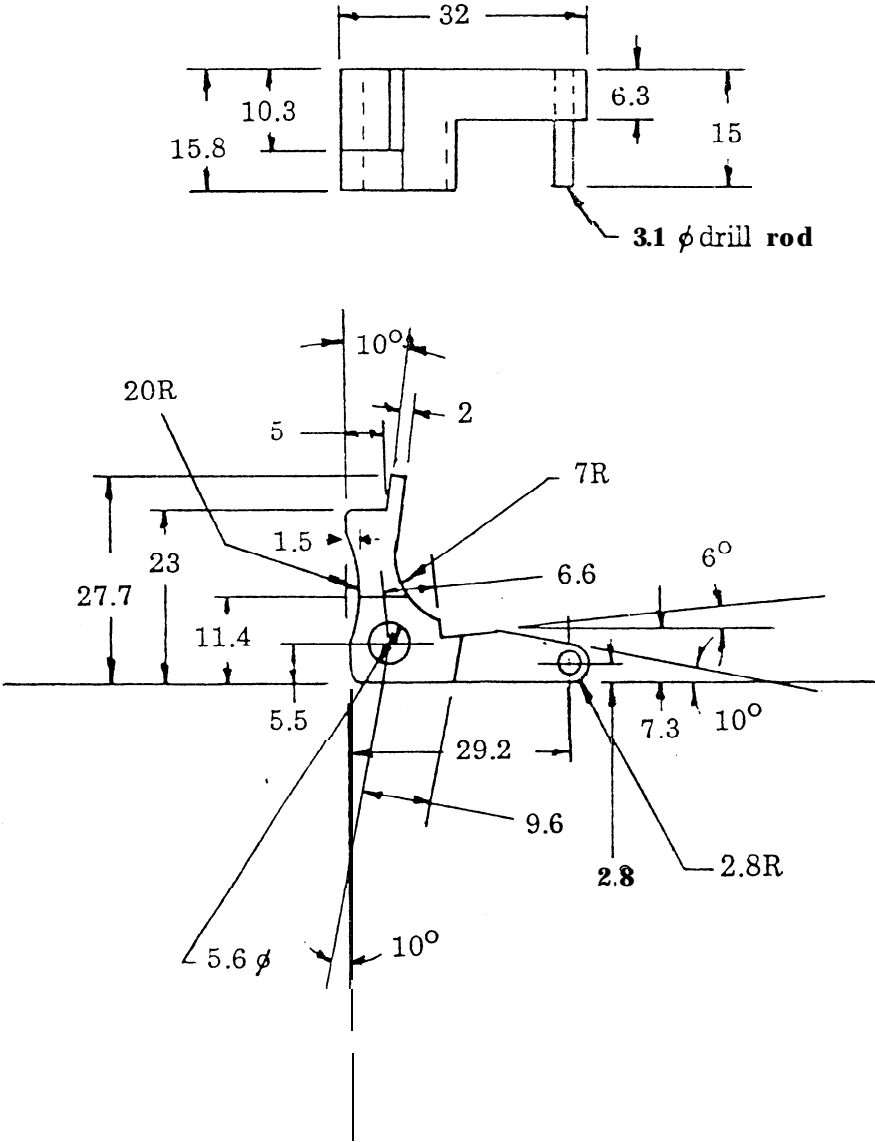


Bottom view

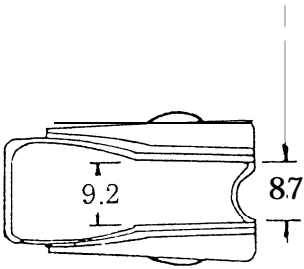


Sear  
Material: AISI 4140 or equivalent  
Harden to Rc 55

Scale: 1:1

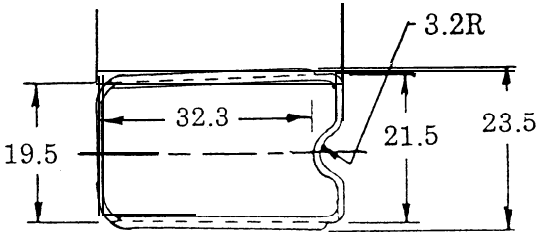
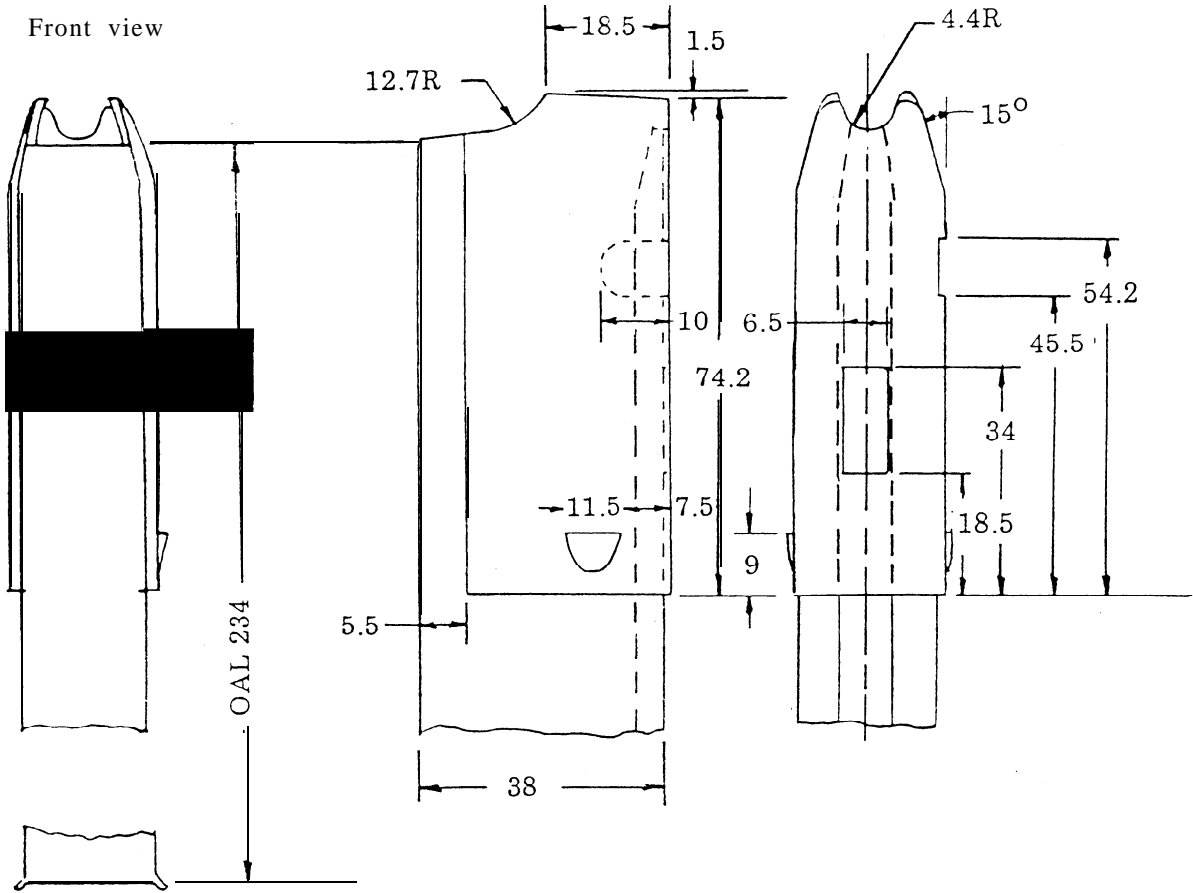


Top view



Magazine  
Material: 1mm steel stock

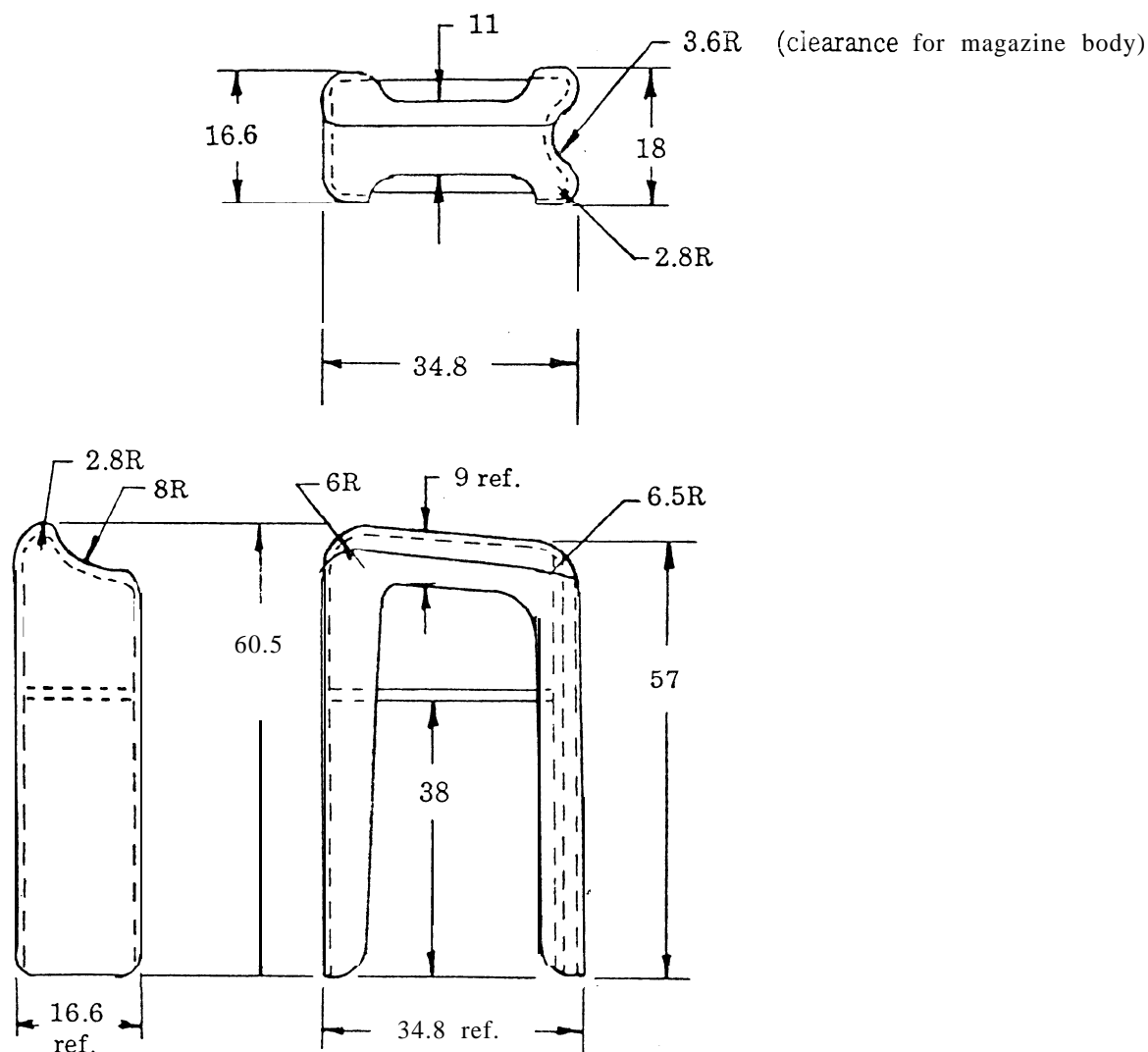
Rear view



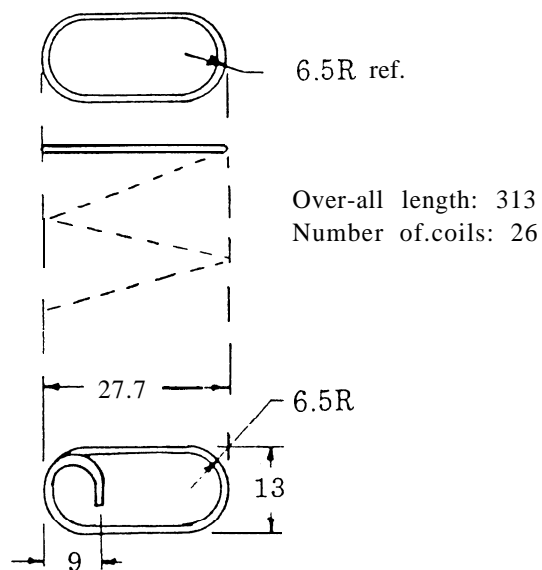
Bottom view

Magazine follower  
Material: low carbon steel

Scale: 1:1



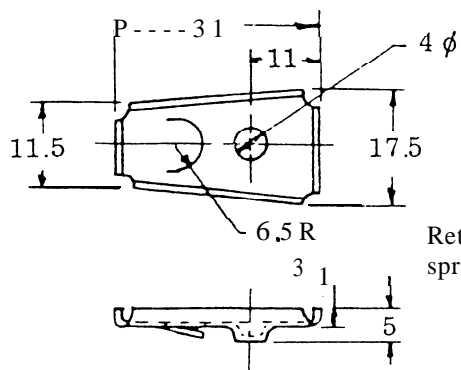
Note: The magazine follower is a complex stamping made on a progressive die. To make a follower in a simpler way is to follow the Degtyarev DP LMG approach — using a dummy round as the last one in the magazine. Thus a simple, flat follower with a dummy round soldered and/or screwed to it will replace a complicated stamping.



Magazine spring

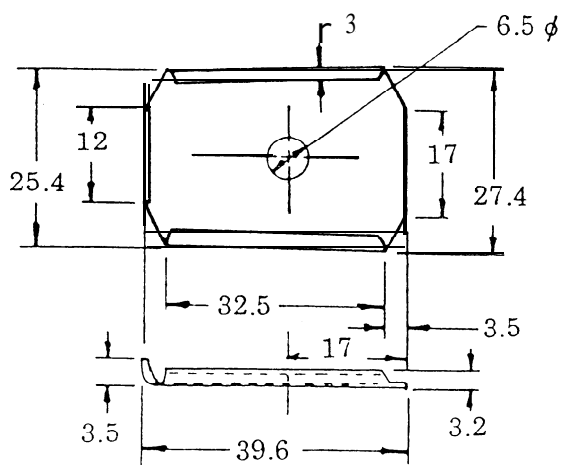
Material: Music wire 1.5mm dia.

Scale: .87:1



Magazine bottom retainer

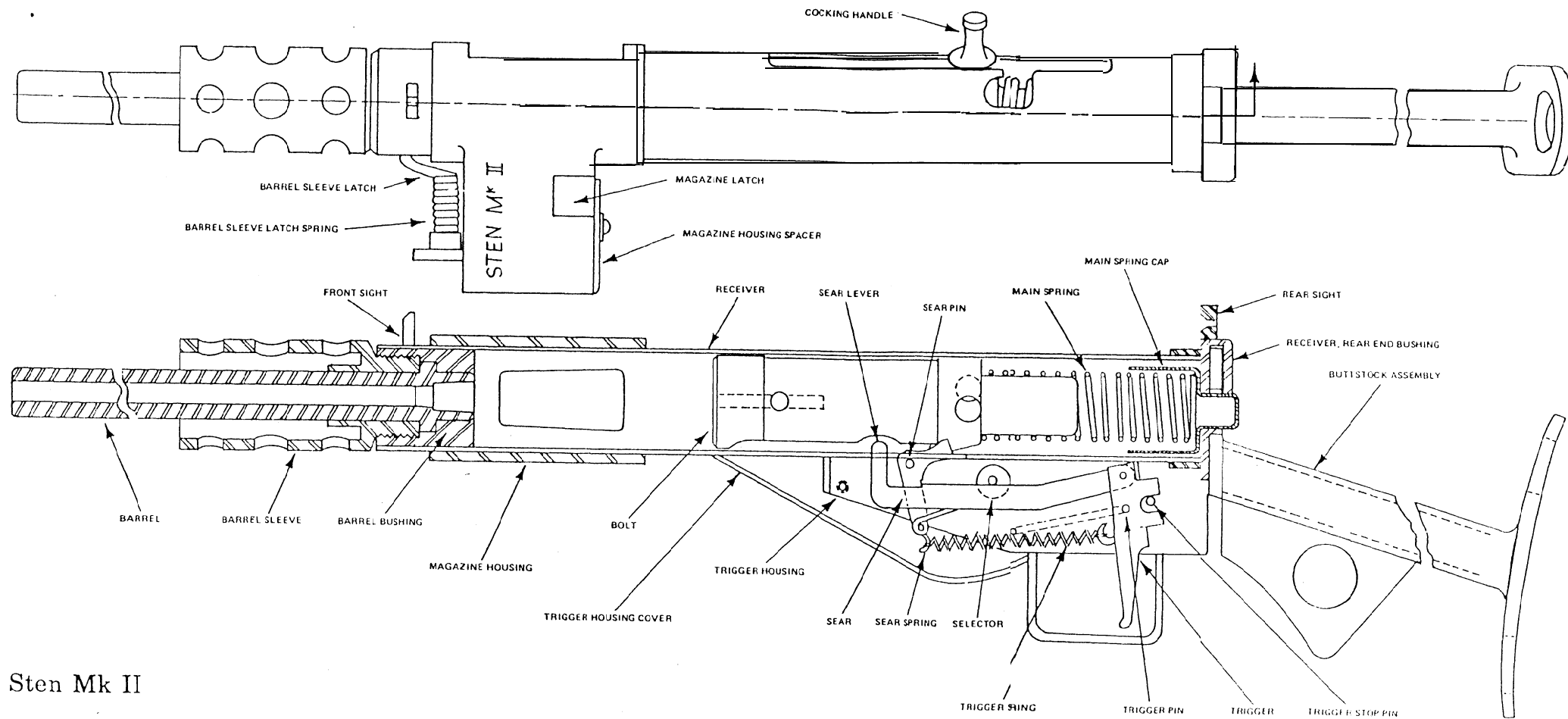
Material: 1mm mild steel



Magazine bottom plate

Material: 1mm mild steel

Scale: .87: 1



Sten Mk II